Each

Thursday, 3/23/2006 3:51:59 PM Kim Johnston User: Sheet : CU-DAROU | Dart | | copters Services **Drawing Name** : BUSHING Customer Job Number : 26361 : 10175 **Estimate Number** : NA : D2570 **Part Number** P.O. Number S.O. No. : NIA : D2570 REV A : 3/23/2006 **Drawing Number** This Issue : NC : N/A **Project Number** Prsht Rev. : 3/23/2006 : MACHINED PARTS Type **Drawing Revision** First Issue : NIA : 25827 **Previous Run** Material **Due Date** : 4/10/2006 Qty: 500 Um: Written By Checked & Approved By Re-format; Removed finishing; Material change K : Est E 02.08.29 Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M303R0750 303 Round Bar .75" 1.0 Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) M100415 150" Material: Ø0.750 AISI 303 SS Rod (M303R0.750) .Batch M100629 118" M100157 194" 2.0 HARDINGE HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 MS 06/05/04 Deburr and tumble INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 36 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 4.0

PACKAGING RESOURCE #1

5.0

Comment: SECOND CHECK

PACKAGING 1

Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

5<u>0-0</u>

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #: Fault	Category:	NCR: Yes	No) DQ	A: <u>S</u>	Date: <u>∠</u>	0686127	

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	QC Inspecto
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NOTE: Date & initial all entries

Date:

Thursday, 3/23/2006 3:51:59 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 26361

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL Inspection Level 21

Job Completion



Dart Ae	rospac	e Ltd								
W/O:			WC	ORK ORDER	CHANGES					
DATE	STEP	PROC	EDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	_ Fault Cate	gory:	NC	R: Yes	No DQ /	A :	Date:	
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NCR:		W	ORK ORD	ER NON-COI	NFORMANC	E (NCR)		7	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Des	scription	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26361
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X Fire	st Article	Pro	ototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.803	V			
0.060	+/-0.005	.063	/			
R0.010	+0.010/-0.000	.010	/			
Ø0.425	+0.000/-0.002	, ৸ঽঽঽ				
Ø0.257	+0.005/-0.000	.257	\ \			
Ø0.750	+/-0.010	.745	\			
0.030 x 20°	+/-0.010	•03X20°			н	
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A. W.						
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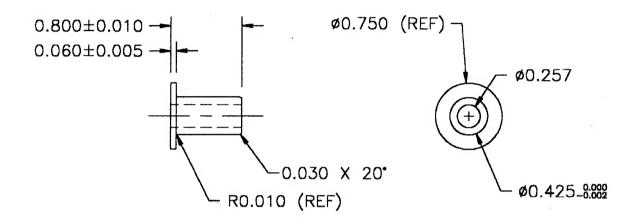
Measured by: MS	Audited by	: 5	Prototype Approval:	N/A
Date: 06/05/04	Date	: 06/04/04	Date:	NIA

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue *	KJ/RF 1.0	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	- 74



DESIGN	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,	LTD CANADA	
CHECKTO	APPROVED	DRAWING NO. D2570	SHEET	REV. A
DATE	1,6	TITLE		SCALE
96:09:16		BUSHING	100011-00W20AWWW	1:1





BREAK ALL SHARP CORNERS 0.010 MAX MATERIAL: AISI 303 — 0.75 DIA STOCK

SHOP COPY RETURN TO ENGINEERING

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NO 2636